

Work Order ID 55383



Page 1

January 15, 2010 8:38:38 AM

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 1/15/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *R*Date: *10/15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3774 Rev *B*

100



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

0.00

*OK 10/15/15
X 20*

Thermoforming Machine

Set up machine program D3774-3 Set up clamping frame as per folio

110



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

0.00

*BB 10/15/15
X 20*

Thermoforming Machine

Cut Blanks

120



THERMOFORMING MACHINE

Thermoform

Memo

0.00

0.00

Thermoforming Machine

Thermoform as per Dwg. D32811 and Folio FTA 011 Dwg. Rev.

R Folio Rev. *C**OK 10/15/15
X 20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

BB
10/01/15
X20

140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Trim to Finished Dimensions

BB
10/01/15
X20

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1) Check dimensions to ensure conformity to drawing tolerances.

BB
10/01/15
X20

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Work Order ID 55383

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Item ID: D3774-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Back, LH/RH

Start Date: 1/15/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

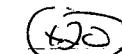
Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

counted



Reject
Qty



Reject
Number

Insp.
Stamp

→ Schedule

170



Packaging

Packaging

Identify as per dwg & Stock Location: 257

0.00

10-1-18

OK SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/18 AF

MF 10-1-18

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Picklist Print

January 15, 2010 8:38:42 AM

Page 1
T

Work Order ID: 55383



Parent Item: D3774-3

Parent Item Name: Seat-Back, LH/RH

Start Date: 1/15/10

Required Date: 1/22/10

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,299.650	213.3400			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	1299.649998	
103106	1.6765	
105330	47.8767	
109455	40.5717	
111710	329.893632	
112585	879.631466	

BB
10/01/15
X20

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DART AEROSPACE LTD	Work Order:	55389
Description: Seat Back	Part Number:	D3774-3
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: RS

Date: 10/05/17

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.37	✓			
33.9	+/-0.100	33.9	✓			
0.085	Min	.0985	✓			
0.100 .065	Min	.071	✓			
0.100	Min	.104				
0.100	Min	.114				
0.100	Min	.114				
0.100	Min	.118				
0.100	Min	.110				
0.100	Min	.112				
0.100	Min	.104				

Measured by: RS

Date: 10/05/17

Audited by: S

Date: 10/05/18

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	<u>S</u> <u>N</u>

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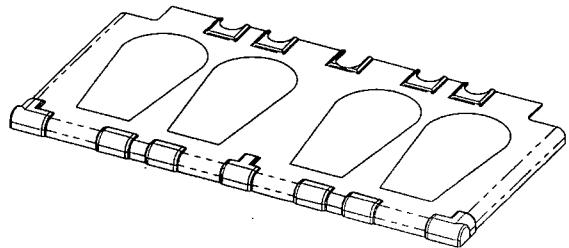
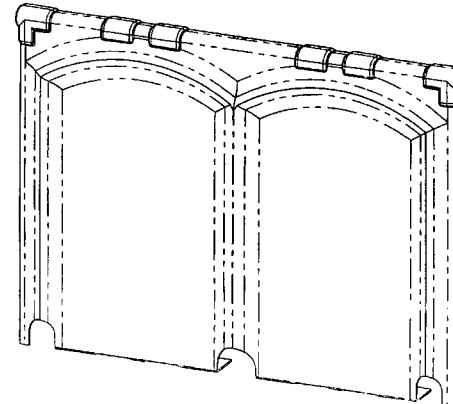
SHOP COPYRETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 55883*110-1-15*D3774-1 SEAT BOTTOMD3774-3 SEAT BACK
RELEASED
08-08-11/08

B	UPDATE CUTCUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES			PH	08.07.25
A	NEW ISSUE			HS	08.06.23
	REV.	DESCRIPTION			BY DATE
	DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	DRAWN	<i>mt</i>	DRAWING NO.	REV. B	
	CHECKED	<i>AS</i>	D3774	SHEET 1 OF 3	
	MFG. APPR.	<i>mt</i>	TITLE	SCALE	
	APPROVED	<i>mt</i>	SEAT	NTS	
	DE APPR.	<i>mt</i>	DATE	08.07.25	
	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD				

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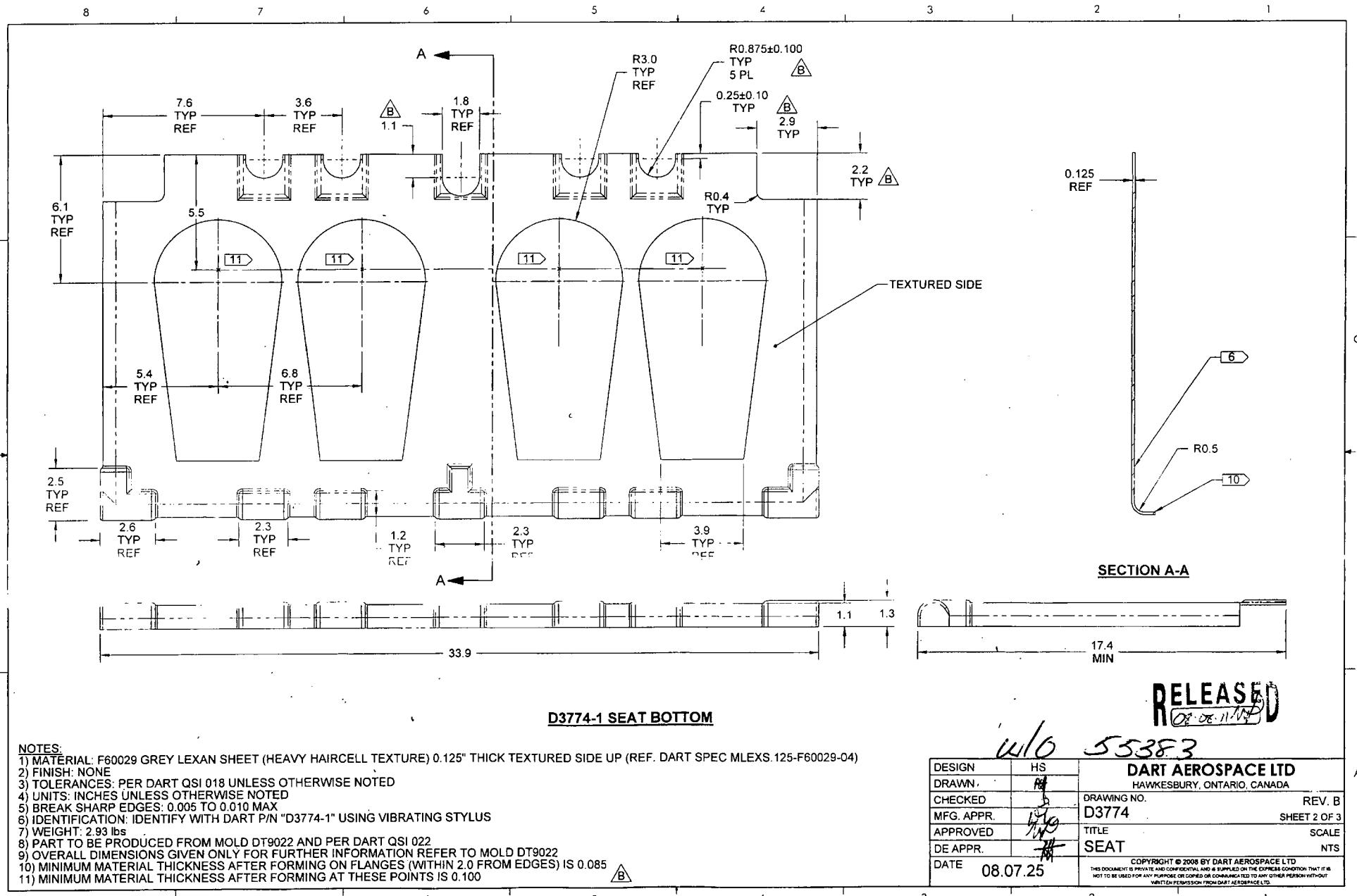
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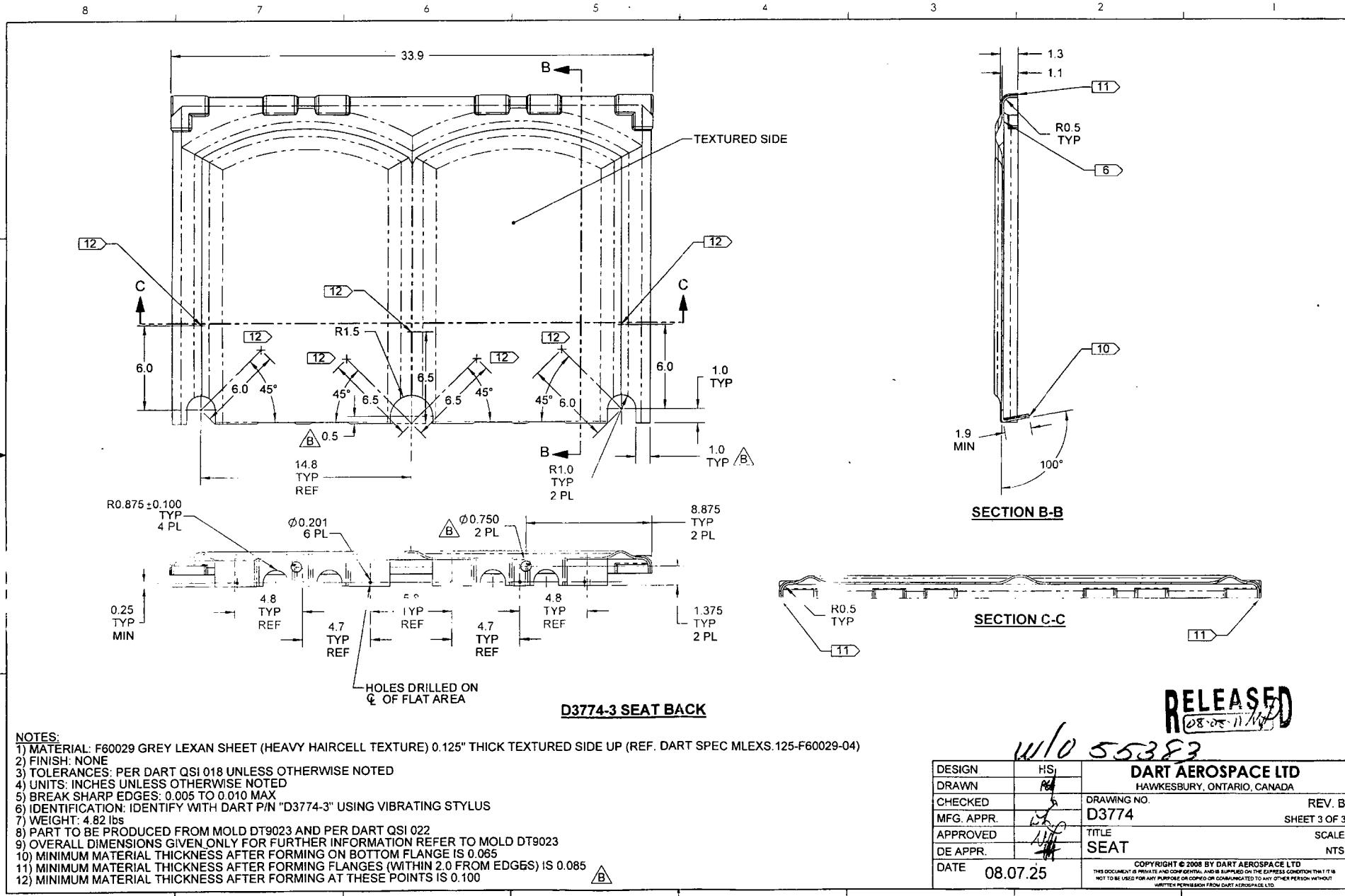
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